

Date: Wednesday, 3/14/2007 3:28:20 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 31212		
Estimate Number	: 10288		
P.O. Number	: <i>N/A</i>	Part Number	: D25771
This Issue	: 3/14/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2577 REV E
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: 3/14/2007 Type : SMALL /MED FAB	Drawing Revision	: E
Previous Run	: 29994	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 3/30/2007 Qty: 40 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est: E 02.09.24 Re-format; Incorporated D2577-101/-11 KJ/ RF est F 06.09.11 now waterjet EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S16GA	1010/1025/A21/6aA SHEET
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Comment: Qty.: 0.8474 sf(s)/Unit Total: 33.8940 sf(s)
 1010/1025/A21/6aA SHEET

M103069 (10) M108434

M109056 (14)

SAD 07/05/09

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2577 (D2577-101 detail)
 Dwg Rev: *E*
 Prog Rev: *E*

ml 07/05/10

(32)

2-Deburr if necessary

SAD 07/05/09

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/05/09

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

MS 07/05/09

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 1-Form on brake as per Dwg D2577 using DT8155 and DT8179
 2-Form joggle as per Dwg D2577 using DT8157
 3-Identify as D2577-1
 4-Deburr if nesasary

SB 07/05/25

(32)

plm 07/05/14

(33)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/06/14

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 3:28:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 31212

Part Number: D25771

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

20520

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using DT8308A & DT8308B as per Dwg D2577

Qty Description

A/R 7560 Hardcoat Rod

Batch

m104368 m104221

FC 07 06 07 (32)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/06/08 (32)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m101601

DR / FL 07-06-11 (32)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-d 07/06/13 (32x)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *EP-16*

07-06-13 (32)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/06/14 (32)

Job Completion



07-06-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

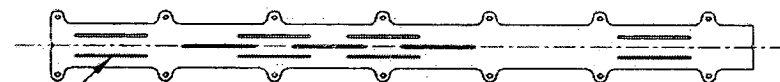
NOTE: Date & initial all entries



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00.09.22

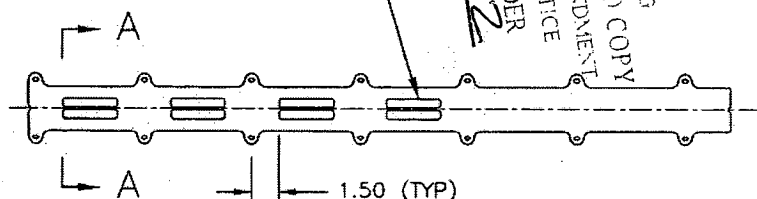
DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
CHECKED	APPROVED	HAMKESBURY, ONTARIO, CANADA	
DATE	TITLE	DRAWING NO.	SHEET 1 OF 5
00.09.22	WEARSHOE	D2577	
A	NEW ISSUE		SCALE 1:10
B	ADD HARDCOAT WELDS		
C	CHANGE HOLES TO OBOUNDS		
D	CORRECTED DIMENSIONS ON -1 & -3		
E	ADD D2577-101/-11/-13 INCORPORATE DE09176		

7560 HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



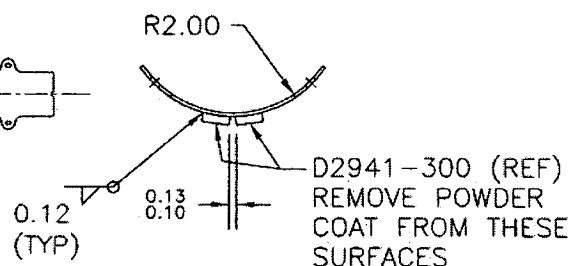
D2577-1 & D2577-3 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2941-300
SHWAYDER WEAPADS
(8 PLACES)



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31212

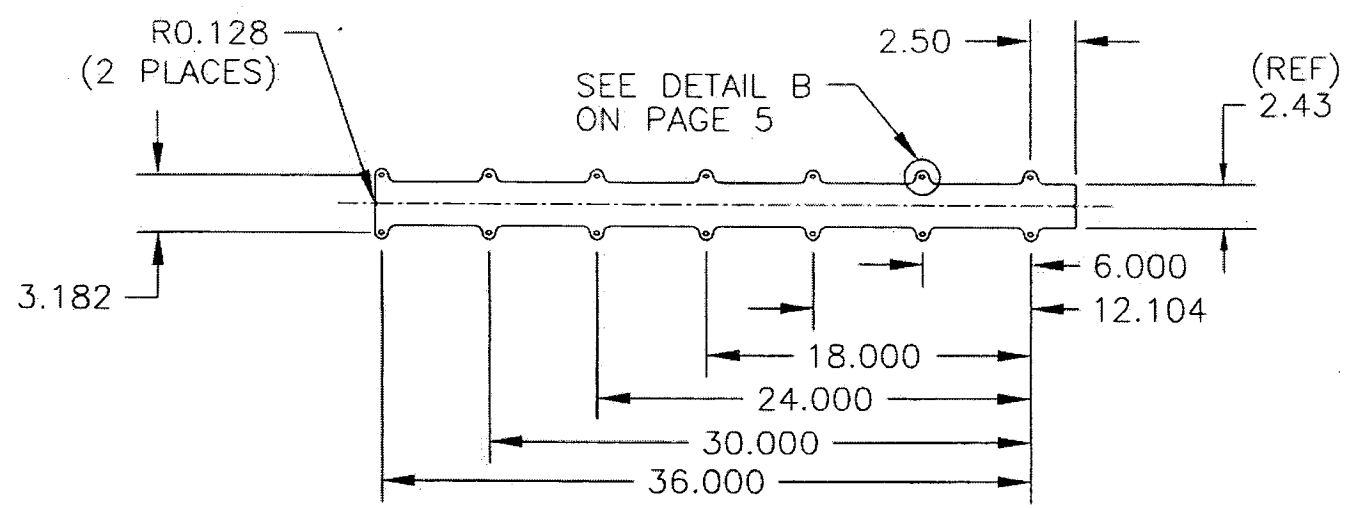
SECTION A-A
SCALE 1:5



D2577-21 & D2577-23 WEARSHOE
MAKE FROM D2577-11 AND D2577-13 RESPECTIVELY
FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN	DRAWN BY	DART AEROSPACE LTD
✓	CP	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
✓	✓	D2577
DATE	TITLE	REV. E
00.09.22	WEARSHOE	SHEET 2 OF 5
		SCALE
		1:10



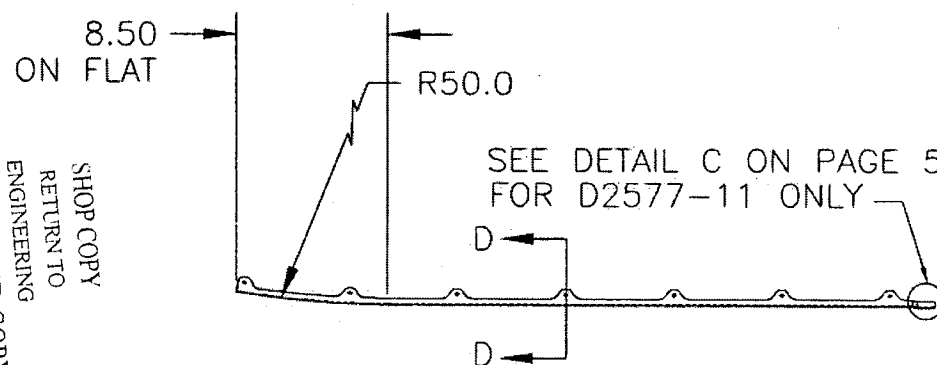
D2577-101 FLAT PATTERN

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2577-11 & D2577-13 LONGITUDINAL BEND

MAKE FROM D2577-101

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
00.09.22

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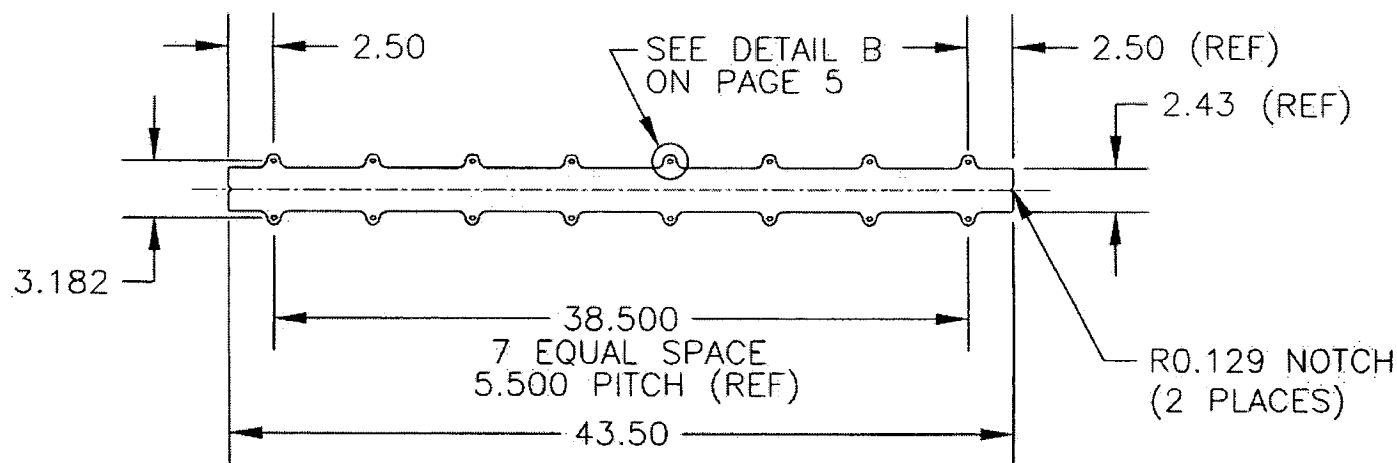
DART



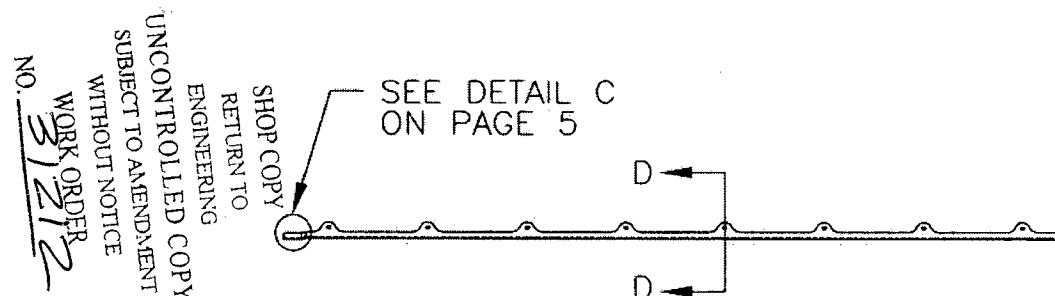
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CHECKED	APPROVED	HAMKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. E
00.09.22	D2577	SHEET 3 OF 5
	TITLE	SCALE
	WEARSHOE	1:10

RELEASED
00.01.26

D2577-5 FLAT PATTERN



D2577-5 LONGITUDINAL BEND



D2577-5 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

FINISH: POWDER COAT GREY (4.3.5.6) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

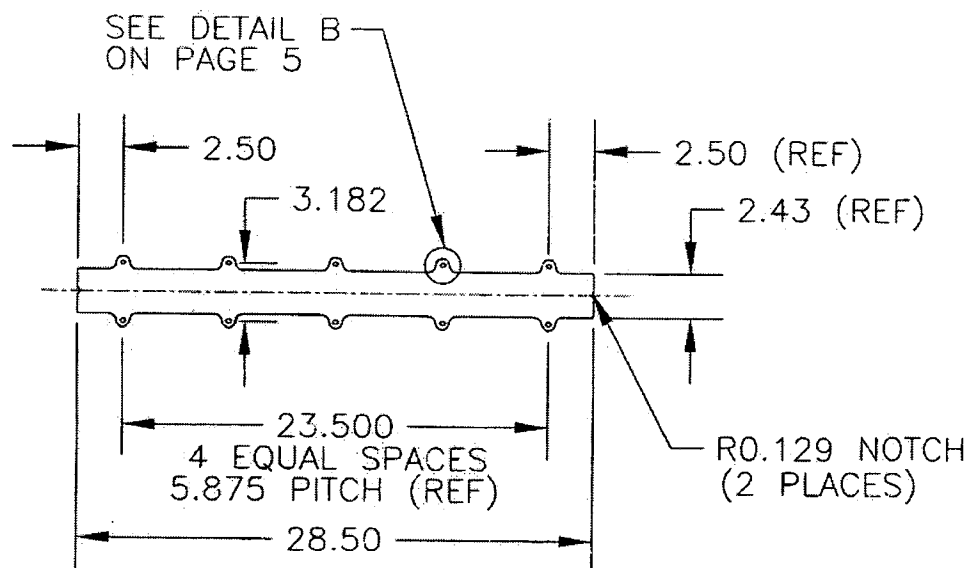
DART



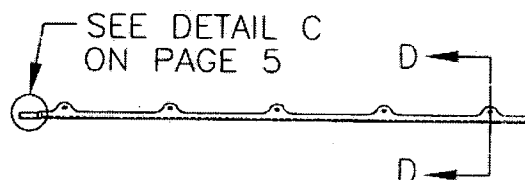
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CHECKED	APPROVED	DRAWING NO. D2577
DATE 00.09.22		TITLE WEARSHOE
		REV. E SHEET 4 OF 5 SCALE 1:10

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D2577-7 FLAT PATTERN



D2577-7 LONGITUDINAL BEND



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WORK ORDER
NO. 31212

D2577-7 WEARSHOE

BREAK ALL SHARP CORNERS 0.010 TO 0.020

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570

SERIES STEEL 0.063 THICK

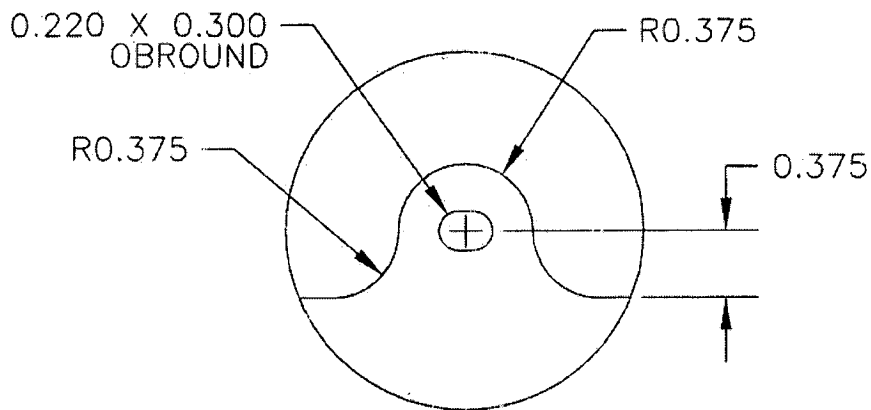
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TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



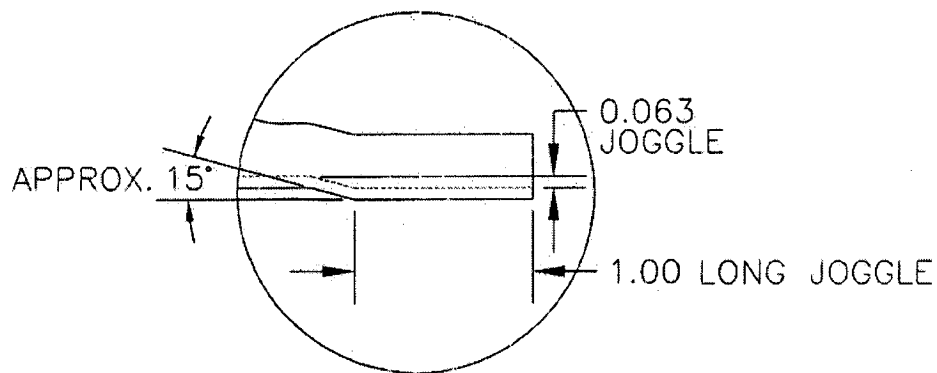
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CHECKED #	APPROVED #	DRAWING NO. D2577	REV. E SHEET 5 OF 5
DATE 00.09.22		TITLE WEARSHOE	SCALE 1:10

DETAIL B (SCALE 1:1)

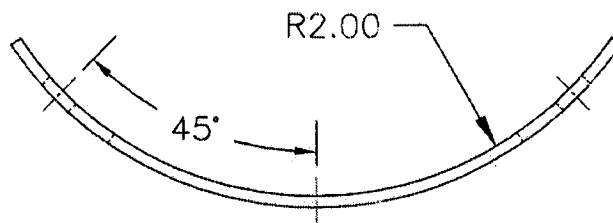


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00.09.22

DETAIL C (SCALE 1:1)



SECTION D-D (SCALE 1:1)



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NO. 31212

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DART AEROSPACE LTD		Work Order: 31212
Description: Bearpaw wear plate		Part Number: D25771
Inspection Dwg: D2577 Rev+		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 3.182	+/- 0.010	3.187	✓		Vern	
B 2.43	+/- 0.030	2.44	✓		Vern	
C 0.220	+/- 0.010	0.218	✓		Vern	
D 0.300	+/- 0.010	0.299	✓		Vern	
E 0.063	+/- 0.010	0.060	✓		Vern	
F 36.00 0	+/- 0.010	36.00 0	✓		M-T	
G 30.00 0	+/- 0.010	30.00 0	✓		M-T	
H 24.000	+/- 0.010	24.000	✓		M-T	
I 18.000	+/- 0.010	18.000	✓		M-T	
J 12.104	+/- 0.010	12.107	✓		M-T Vern	
K 6.000	+/- 0.010	6.066	✓		M-T Vern	
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <u>SAD</u>	Audited by:	Prototype Approval:	N/A
Date: <u>07/05/09</u>	Date: <u>070510</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	